

Work Order ID 108294

108294

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Item ID: D044-713-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Passenger Door Window Fits LH or RH

Start Date: 10/11/13 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 10/18/13 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100		0.00							
100	DOCUMENT CONTROL								
DC		0.00							
Document Control	Memo Photocopy bluefiles & DT8721 Cutting Template and create labels per PPP D044-713-015CHG001								
110	Pick Kit	0.00							
110									
Packaging		0.00							
Packaging	Memo								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC		0.00							
Quality Control	Memo								

DAS
6
9-89

DAS
33
9-89 13-10-18

B 10 22

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-713-015								
	Location: <u>FG 020</u>								
	PPP Rev: <u>A</u>								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

2 13-10-2213-10-2213-10-22

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Required Qty: 2.00

Comments: IPP Rev:A05.03.22New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D18721 template	68-6 27 SVC	2x		Manufactured	No	110	Each	0.0000	1	2			
D2126 Seal				Manufactured	No	110	f	358.2940	6	13	DAS 33 9-89		
(D2126-0720) cut 1 at 72.00"													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST405		358.294							
				102729		317.98							
				89058		40.314							
D2977 Hinge Bracket	DAS 27 9-89	13-10-18		Manufactured	No	110	Each	190.0000	1	2	DAS 33 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST022		190							
				14106		8							
				19560		182							
D3279-1 Window	DAS 27 9-89	2x		Manufactured	No	110	Each	8.0000	1	2	DAS 33 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST225		8							
				84393		8							
MS21042-08 USE MS21042L08	DAS 27 9-89	2x		Purchased	No	110	Each	574.0000	1	2	DAS 33 9-89		13-10
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST314		474							
				123525		474							
				ST315		100							
				123352		100							

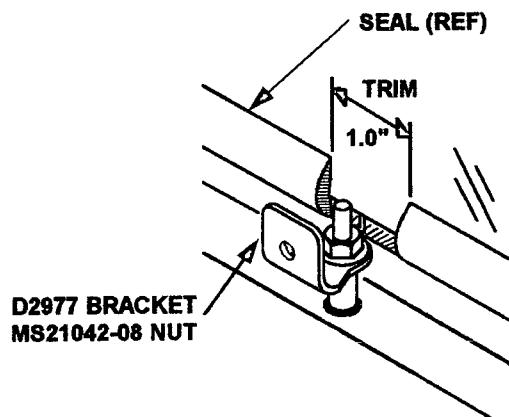


FIGURE 4 – D044-713-015 Passenger Door Window Kit – Tab Installation

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-713-011 Crew Door Window Kit	1.5 lb 0.68 kg	±24 in ±0.61 m	±36 in-lb ±0.43 m-k-g	66 in 1.68 m	99 in-lb 1.1 m-k-g
D044-713-013 Bubble Window Kit, LH	2.5 lb 1.1 kg	-28 in -0.71 m	-70 in-lb -0.78 m-k-g	66 in 1.68 m	165 in-lb 1.8 m-k-g
D044-713-014 Bubble Window Kit, RH	2.5 lb 1.1 kg	+28 in +0.71 m	+70 in-lb +0.78 m-k-g	66 in 1.68 m	165 in-lb 1.8 m-k-g
D044-713-015 Passenger Door Window Kit	1.2 lb 0.54 kg	±23 in ±0.58 m	±28 in-lb ±0.31 m-k-g	83 in 2.11 m	100 in-lb 1.1 m-k-g

5.0 PARTS LIST

Qty -011	Qty -013	Qty -014	Qty -015	Part Number	Description
X				D044-713-011	CREW DOOR WINDOW KIT, (FITS LH & RH)
	X			D044-713-013	BUBBLE WINDOW KIT, LH
		X		D044-713-014	BUBBLE WINDOW KIT, RH
			X	D044-713-015	PASSENGER DOOR WINDOW KIT, (FITS LH & RH)
			1	D2126-0720	SEAL
1	1	1		D2126-0903	SEAL
	1			D3269-1	BUBBLE WINDOW, LH
		1		D3269-2	BUBBLE WINDOW, RH
1				D3277-1	WINDOW
			1	D3279-1	WINDOW
	1	1		D3312-1	PLACARD
			1	D2977	BRACKET
			1	MS21042-08	NUT
*1	*1	*1		DT8720	D044-713-011/-013/-014 CUTTING TEMPLATE (FWD DOOR)
			*1	DT8721	D044-713-015 CUTTING TEMPLATE (AFT DOOR)

* Not to be installed. Cutting template only.